

Work Order ID **92120-2**

Tuesday, October 23, 2012 4:11:59 PM

**\*92120\***

Page 1

*split*

Item ID: PB67-43001-11

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *MUS*

Date: *12-10-25*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-11	Rev C

100

0.00

**\*100\***

Large Fab

Large Fab

Large Fab

Memo

0.00

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

3- grind weld flush in area of PB67-43001-249 only

4- install helicol insert as per dwg

*(4x)*

*cc 12-12-4*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*\* 4*

*cc 12-12-05*

*DAS 18 8-00*



# Work Order ID 92120

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\*92120\*

Page 2

Item ID: PB67-43001-11 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fw Adjustable Blade Support Assembly  
 Start Date: 10/23/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 11/2/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 *120* QC Quality Control	QC5- Inspect part completeness to spec on W/O	0.00				4			
	Memo	0.00							

150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				4		26 12-12-5	
	Memo	0.00							

160 *160* Powdercoat Powder Coating	Green Sandtex(Ref.4.3.5.8) per QSI005 4.3	0.00				4x			
	Memo	0.00							

1- MASK TUBE FROM BASE TO GUSSET START TIME:  
 OVEN TEMPERATURE: 320°F FINISH  
 TIME: 2:45 3:15

m18144

m1  
12/12/10





# Work Order ID 92120

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Item ID: PB67-43001-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

4 0 12/12/10

180

Small Fab

0.00

\*180\*

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

12 12/12/19

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Memo

0.00

Quality Control

16 12/12/19

1











# Picklist Print

Tuesday, October 23, 2012 4:11:59 PM

Page 1

Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Ewf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec  
dwg EC verified by:DD

IPP Rev B 10.09.27 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67 PB67-43001-67		Manufactured	No		B93495 = 4		Each	1.0000		4		11-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				85187		1							
PB67-43001-247 Inner Tube		Manufactured	No		B90926 = 4	100	Each	0.0000	1	4		11-11-30	
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	3.0000	1	4		11-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438	B90927	3							
				52480		3							
PB67-43001-253 Gusset		Manufactured	No			100	Each	7.0000	1	4		11-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
				85185		7							
PB67-43001-254 Gusset		Manufactured	No			100	Each	16.0000	1	4		11-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16							
				52481		16							
MS124780 HELICAL INSERT		Purchased	No			180	Each	82.0000	1	4		11-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		82							
				111064		82							



# Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-10

Purchased

No

180

Each

416.0000

8

32

Screw

*12.12.19*

Location

Loc Qty

Loc Code

308

*123522*

8

*128*

122441

8

GA

100

120449

100

ST291

5

120120

5

ST305

300

122815

300

ST308

3

122027

3

NAS1149D0316J

Purchased

No

180

Each

400.0000

8

32

Washer

*12.12.19*

Location

Loc Qty

Loc Code

ST298

400

*122151*

400

*128*

NAS1149D0363J

Purchased

No

180

Each

4,785.0000

8

32

Washer

*12.12.19*

Location

Loc Qty

Loc Code

ST294

1854

123248

1254

123355

600

ST297

2820

*122378*

2820

*128*

ST298

111

117601

61

119537

33

120308

17

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Shop Packet Print

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# Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-69

Manufactured No

180

Each

1.0000

1

4

90 Degree Cover Plate

Location

Loc Qty

Loc Code

ST437A

92081 = 1

1

1

52433

1

PB67-43001-83

Manufactured No

180

Each

5.0000

1

4

PB67-43001-83

Location

Loc Qty

Loc Code

ST444

B90819 = 1

5

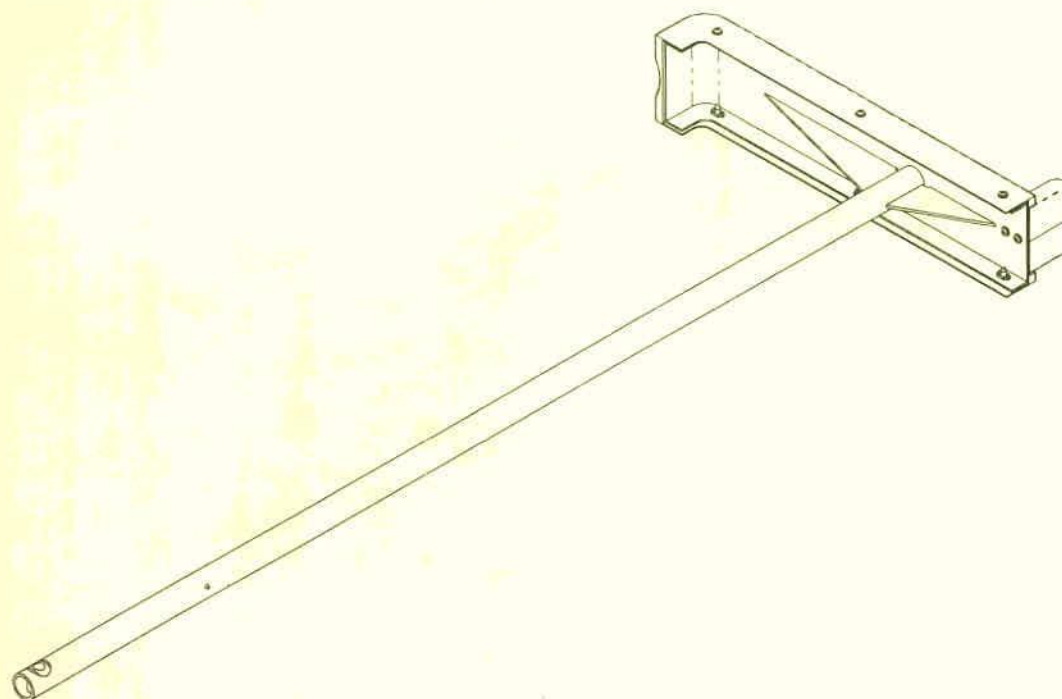
53240

5

1







**B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY**

ITEM	QTY -11	P/N	DESCRIPTION
1	X	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

STATION COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AGREEMENT  
WITHOUT NOTICE  
WORK ORDER

92120 MJS

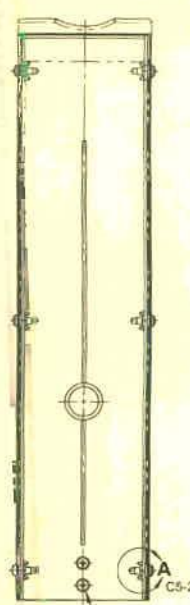
12-10-25

**RELEASED**  
2010-09-16  
MD

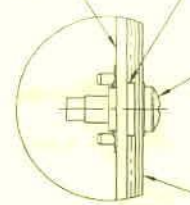
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-11	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS	
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



92120



MS27039-1-10 SCREW  
NAS1149JD0316J WASHER  
2 PL [8]



SECTION A-A B7.2  
SCALE 4X, 6 PL

B67-43001-11W FWD ADJUSTABLE  
BLADE SUPPORT WELDMENT REF  
NAS1149D0363J  
WASHER  
MS27039-1-10 SCREW [8]  
NAS1149JD0316J WASHER  
B67-43001-69 90-DEGREE  
COVER PLATE  
REF

B67-43001-69  
90° COVER PLATE ASSEMBLY



B67-43001-11W FWD ADJUSTABLE  
BLADE SUPPORT WELDMENT

B67-43001-83  
D-PAD ASSEMBLY, SHORT

**B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY**

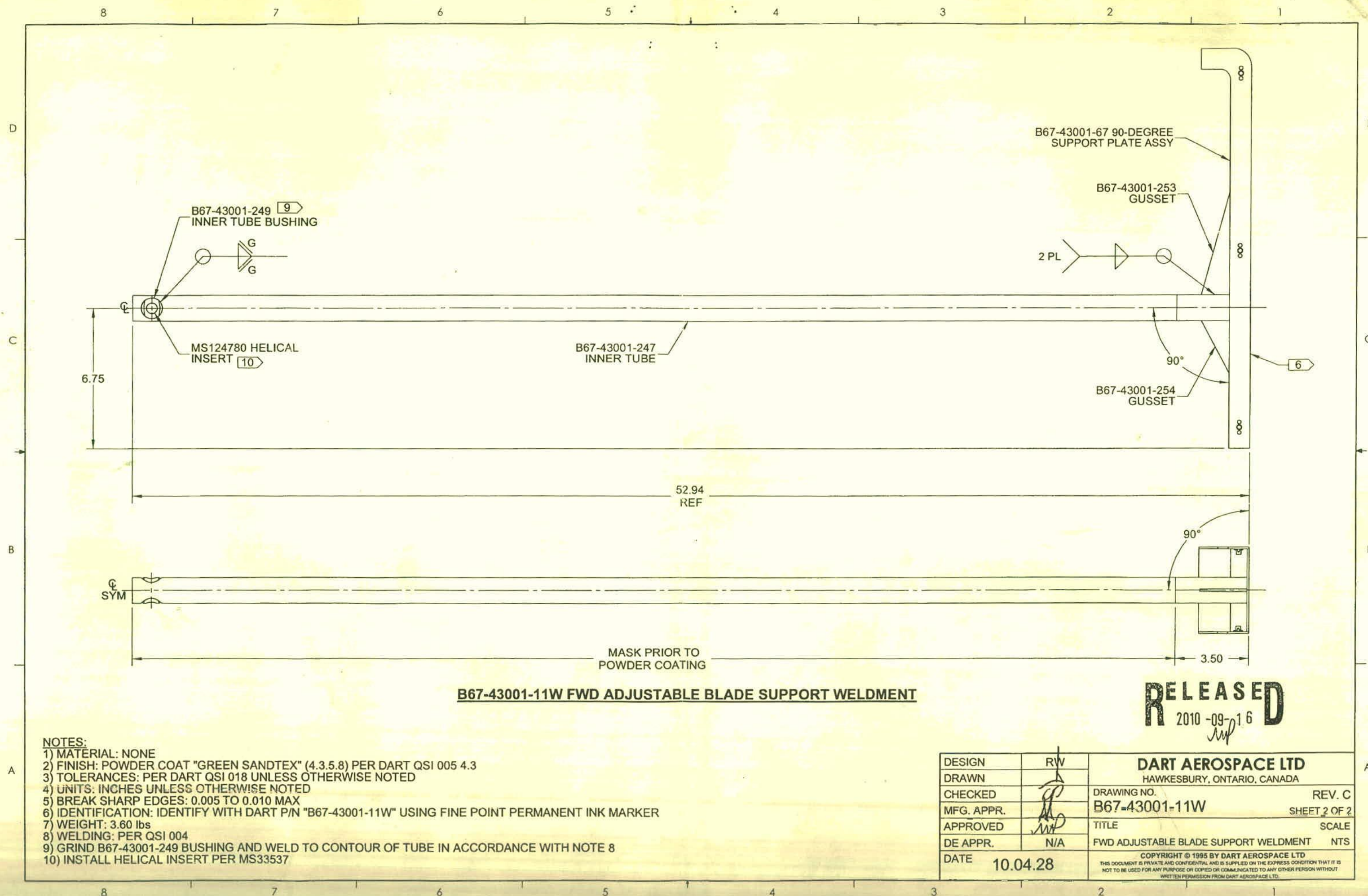
- NOTES:
- 1) MATERIAL: NCNE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 8.83 lbs
  - 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL  $\phi 0.250$  TO  $\phi 0.257$  HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-11W AND B67-43001-83 TO B67-43001-69

RELEASED  
2010-09-06  
MP

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-11	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS
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**B67-43001-11W FWD ADJUSTABLE BLADE SUPPORT WELDMENT**

ITEM	QTY -11W	P/N	DESCRIPTION
1	X	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-247	INNER TUBE
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-249	INNER TUBE BUSHING
7	1	MS124780	HELICAL INSERT

RELEASED  
2010-09-16

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REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. B67-43001-11W REV. C SHEET 1 OF 2	
CHECKED		TITLE FWD ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS	
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APPROVED		DATE 10.04.28	
DE APPR.	N/A		



